

Work Order ID 61481

Thursday, August 26, 2010 2:41:52 PM

Page 1

Item ID: D3137-043

Accept

Revision ID:

Item Name: Bracket Assembly

Start Date: 8/26/2010 Start Qty: 12.00

Required Date: 9/6/2010 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

Date: 10-8-26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3137

Rev F

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (.500" x 2.000") 5.570" long

SF 10/09/04

12 8

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3137-7 as per Folio FA3308 and Dwg D3137-
7□2-Deburr□3-Scribe batch number

SF 10/09/05

12 8

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SF 10/07/05

12 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61481

Thursday, August 26, 2010 2:41:52 PM

Page 2

Item ID: D3137-043

Accept

Revision ID:

Item Name: Bracket Assembly




Start Date: 8/26/2010 Start Qty: 12.00

Required Date: 9/6/2010 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				12	0		
140  Small Fab Small Fab	Small Fab Memo Assemble D3137-043 as per Dwg D3137	0.00 0.00							8/30/09/20 (12)
150  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00						(412)	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 61481

Thursday, August 26, 2010 2:41:52 PM



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Item ID: D3137-043	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Bracket Assembly				
Start Date: 8/26/2010	Start Qty: 12.00		Cust Item ID:	
Required Date: 9/6/2010	Req'd Qty: 12.00		Customer:	
Reference:				

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Identify as per dwg & Stock Location: <u>235A</u>	0.00							
Packaging	Memo	0.00					10/9/20	sf	120
Packaging									
170 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

MF
10-9-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Thursday, August 26, 2010 2:41:57 PM

Page 1

Work Order ID: 61481

Parent Item: D3137-043

Parent Item Name: Bracket Assembly




Start Date: 8/26/2010

Required Date: 9/6/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 04.02.18 New issue KJ/DS
IPP Rev B 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS24694-S101  Screw		Purchased	No			100	Each	74.0000	1	12			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST290A				74					
					110363			74					
D3137-3  Guide		Manufactured	No			140	Each	6.0000	1	12			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235B				6					
					59634			6					
D3137-5  Washer		Manufactured	No			140	Each	13.0000	1	12			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235B				13					
					46740			13					

EP 510/09/20

12

EP 510/09/20

361700 (82)

4

EP 510/09/20

12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, August 26, 2010 2:41:57 PM

Page 2

Work Order ID: 61481



Parent Item: D3137-043



Parent Item Name: Bracket Assembly

Start Date: 8/26/2010

Required Date: 9/6/2010

Start Qty: 12.00

Required Qty: 12.00

M174B0.500X02.000

Purchased

No

140

f

65.2000

0.4643

5.864842



17-4 SS Bar .500 x 2.00

Location

Loc Qty

Loc Code

MAT030

65.2

100843

10.2

103089

18.5

14932

26

19572

10.5

5.8649

SF 10/09/04

Thursday, August 26, 2010 2:41:57 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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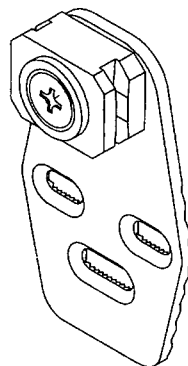
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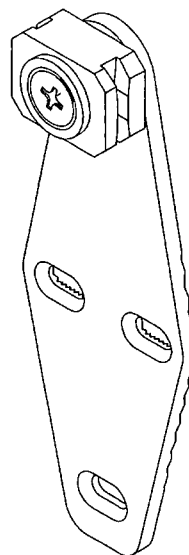
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

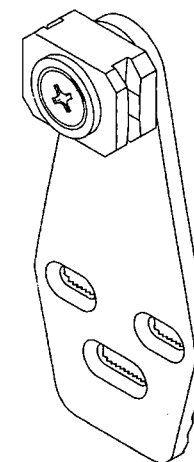
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO ANY NUMBER
 WITHOUT NOTICE
 WORK ORDER
 NO. 61481
8810-8-24



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY



D3137-045 BRACKET ASSEMBLY

RELEASED
 08-06-2017

F	REDRAWN & REFORMATTED IN SOLIDWORKS. SHEET 3 ZONE A 5 DIM 2.38 WAS 2.48. ZONE A 4 0.480 DIM WAS 0.605. ZONE A 8 0.67 DIM WAS 0.79. ZONE B 5 4.850 DIM WAS 4.975 & ZONE B 8 5.29 DIM WAS 5.41. REASON: PART TRIMMED DUE TO INTERFERENCE WITH EXECUTIVE INTERIOR.	AJS	08.05.30
E	ADD -045	RF	05.11.23
D	RE-DESIGN D3137-5; CHANGE DIMS	DS	04.11.03
C	ADD -043	DS	03.08.15
B	ADD RIDGES; ADD MATERIAL PROP	DS	03.01.16
A	NEW ISSUE	DS	02.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3137	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

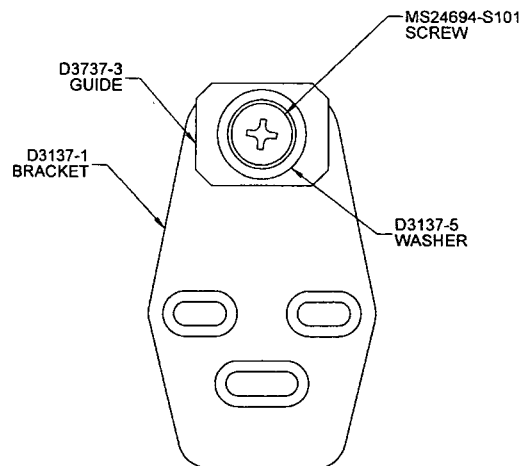
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

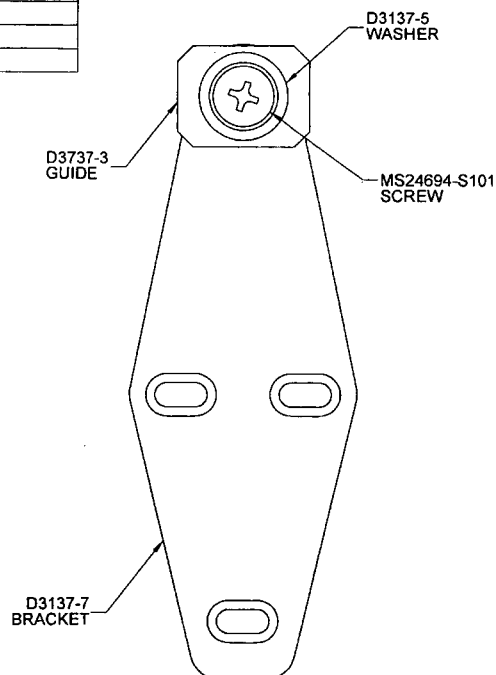
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

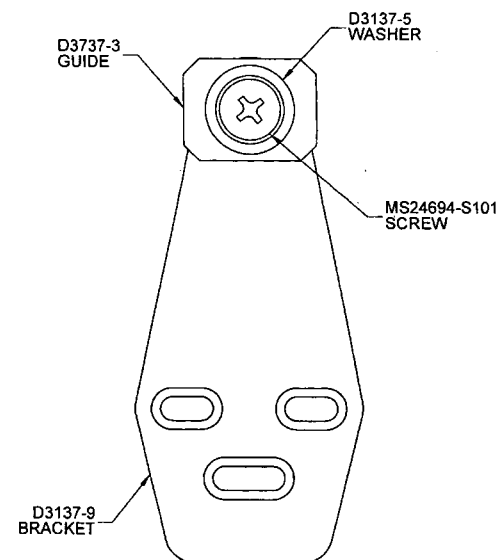
QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3137-041	BRACKET ASSEMBLY
	X		D3137-043	BRACKET ASSEMBLY
		X	D3137-045	BRACKET ASSEMBLY
1			D3137-1	BRACKET
1	1	1	D3137-3	GUIDE
1	1	1	D3137-5	WASHER
	1		D3137-7	BRACKET
		1	D3137-9	BRACKET
1	1	1	MS24694-S101	SCREW



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY






D3137-045 BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs -041
: 0.32 lbs -043
: 0.27 lbs -045

RELEASED
08-06-16/11

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
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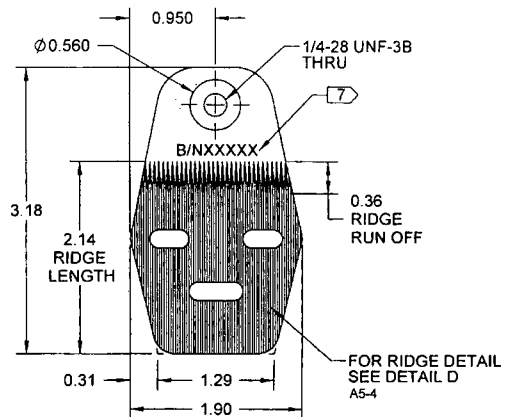
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

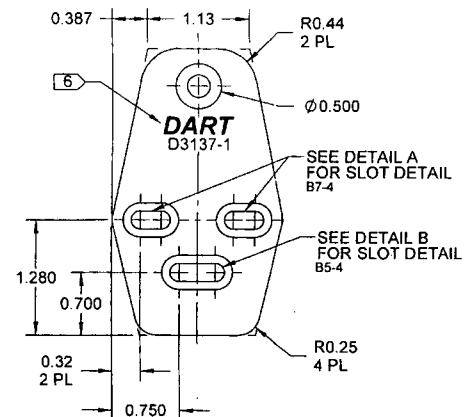
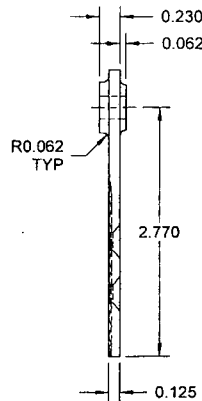
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

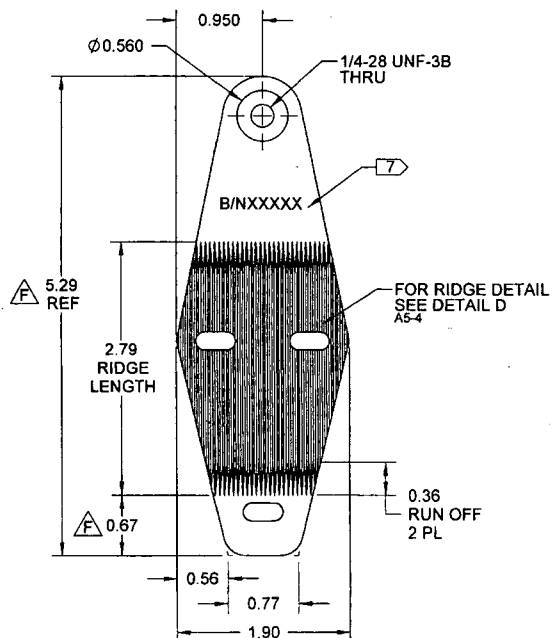
NOTE: Date & initial all entries



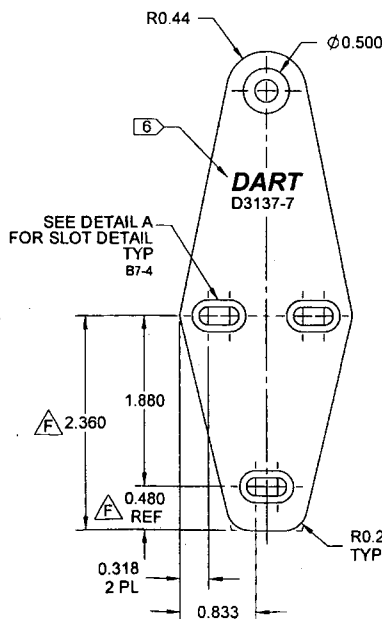
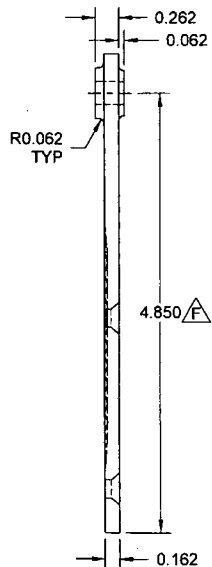
D3137-1 BRACKET



w/o 61481



D3137-7 BRACKET



NOTES:

- 1) MATERIAL: -1 & -7
17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) -1 REPLACES PREMIER P/N B30-23000-105/-105

RELEASED
08-06-26

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
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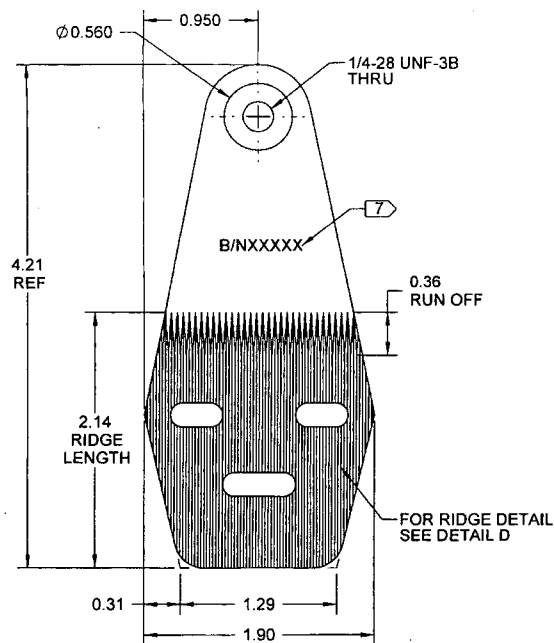
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

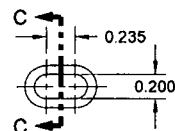
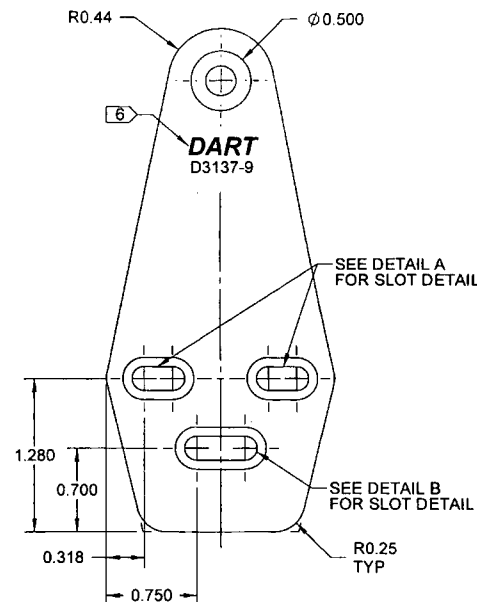
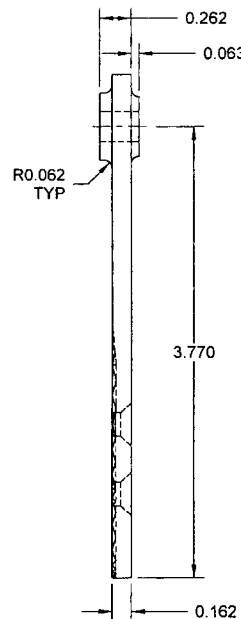
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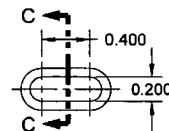
NOTE: Date & initial all entries



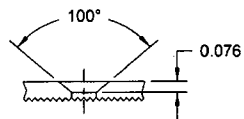
D3137-9 BRACKET



**DETAIL A
(SLOT DETAIL)**



**DETAIL B
(SLOT DETAIL)**



**SECTION C-C
(SLOT DETAIL)**



**DETAIL D
SCALE 2X
(TYPICAL RIDGE DETAIL)**

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) REPLACES PREMIER P/N B30-23000-105/-106

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
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08-05-30

W/O 614.81

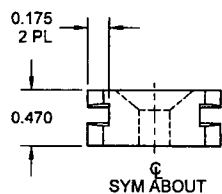
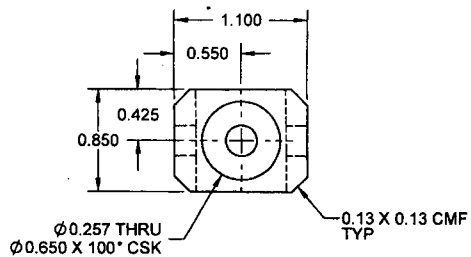
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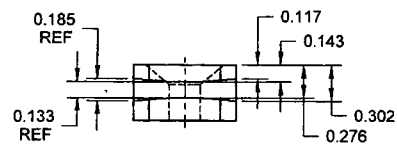
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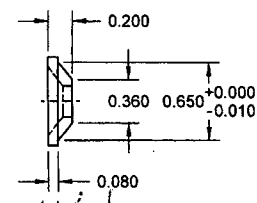
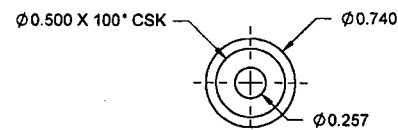
NOTE: Date & initial all entries



D3137-3 GUIDE



D3137-5 WASHER



NOTES:

- 1) MATERIAL: -3
DELIN II 150E OR ACETRON GP ACETAL, BAR
(REF DART SPEC M-DELIN-B)
-5
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)
OR PER-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207
-5 REPLACES PREMIER P/N B30-2300-209

RELEASED
180702-10

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	LAJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LAJS	DRAWING NO.	REV. F
MFG. APPR.	LAJS	D3137	SHEET 5 OF 5
APPROVED	LAJS	TITLE	SCALE
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 61481
Description: Bracket		Part Number: 03137-7
Inspection Dwg: 03137	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.91	±.030	5.288	✓		Vern	SF-12
2.79	"	2.765	✓		"	
.67	"	.69	✓		"	
.56	"	.56	✓		"	
.77	"	.77	✓		"	
1.90	"	1.889	✓		"	
.36	"	.36	✓		"	
Ø.560	±.010	.561	✓		"	
Ø.500	"	.505	✓		"	
.162	"	.166	✓		"	
4.850	"	4.850	✓		"	
.062	"	.065	✓		"	
.262	"	.264	✓		"	
R.062	"	.062	✓		Rad gauge	
.833	"	.833	✓		High gauge	
.318	"	.315	✓		V SF-12	
.430	"	.433	✓		"	
1.880	"	1.880	✓		High gauge	
2.360	"	2.360	✓		"	
.235	"	.232	✓		V SF-12	
.200	"	.199	✓		"	
.076	"	.070	✓		"	
Ø.030	"	.030	✓		- JL-7 depth mic.	

Measured by: SP
Date: 10/09/05

Audited by: H.A
Date: 10/09/16

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	